

Work Order ID 69439

Wednesday, May 11, 2011 10:10:17 AM



Page 1

Item ID: D3730-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Angle				
Start Date: 5/11/2011	Start Qty: 8.00		Cust Item ID:	
Required Date: 5/16/2011	Req'd Qty: 8.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date: 11-05-11	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3730	Rev B								
100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo Cut to Lengh as per Dwg D3730	0.00		11/05/19					
110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv								
Conventional Milling Machine	Memo 1- drill holes as per dwg D3730-2-Deburr	0.00		11/05/19					
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00		11/05/19					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Angle

Start Date: 5/11/2011 Start Qty: 8.00

Required Date: 5/16/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Grind radius as per dwg D3730-2- Deburr if necessary

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



11/05/19

10X 0 m 11/05/19

8 11/05/19

(40)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3730-1

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Item Name: Angle

Start Date: 5/11/2011 Start Qty: 8.00

Required Date: 5/16/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00


HandFinish

Memo

0.00

Hand Finishing

10 0 11 11/05/19

170

QC3- Inspect Part Finish

0.00


QC

Memo

0.00

Quality Control

10 BR 11-5-19

180

Identify as per dwg & Stock Location: _____

0.00


Packaging

Memo

0.00

Packaging

11/5/19

W/O:		WORK ORDER CHANGES					
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Page 4

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Setup Start

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Item Name: Angle

Start Date: 5/11/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24
MF
11-05-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

Wednesday, May 11, 2011 10:10:43 AM

Page 1

Work Order ID: 69439

Parent Item: D3730-1

Parent Item Name: Angle





Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:
IPP Rev:B 08-03-19 chg to revB ecn 1158 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A.750W.125		Purchased	No			100	f	20.0000	0.1666	1.402947			
 													

angle .750 x .750 x .125w

Location

Loc Qty

Loc Code

MAT003

20

117481

20

~~1.8~~ 11/05/19
1.8

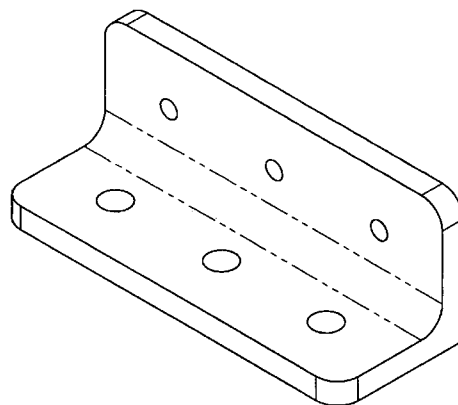
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


D3730-1 ANGLE 

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69439

PD 11-05-11

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) 
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED, SHEET 2 ZONE C4, Ø0.098 HOLES WERE Ø0.159, ZONE 7B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.01.31
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>LE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>DS</i>	D3730	SHEET 1 OF 2	
APPROVED	<i>AP</i>	TITLE	SCALE	
DE APPR.	<i>TH</i>	ANGLE	NTS	
DATE	08.03.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

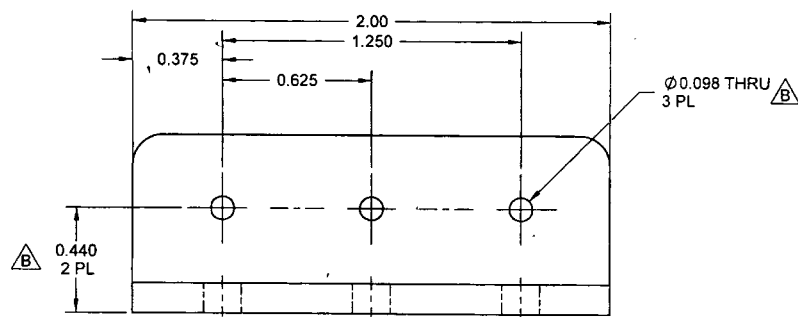
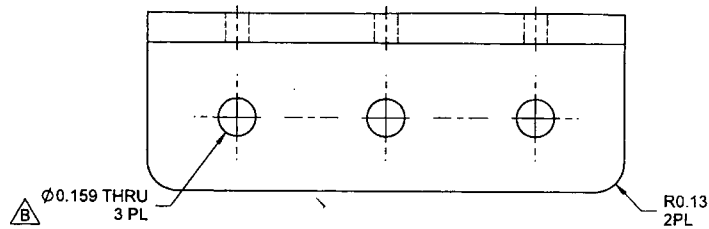
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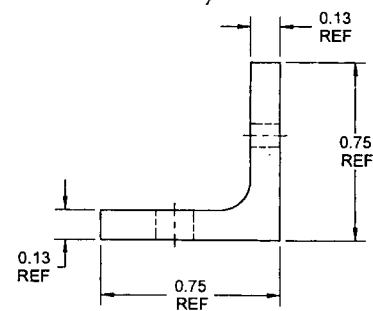
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D3730-1 ANGLE



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3730	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ANGLE	NTS
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DART AEROSPACE LTD	Work Order:	69 439
Description: Angle	Part Number:	D3730-1
Inspection Dwg: D3730 , Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article
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X	Prototype
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[illegible]

Measured by: 	Audited by: 	Prototype Approval:
Date: 11/05/19	Date: 11/05/19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	